

Date: Tuesday, 7/1/2008 10:46:48 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABLE GUARD
Job Number : 40154	
Estimate Number : 12458	
P.O. Number :	Part Number : D29165
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D2916 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 39593	Material :
Written By : <u>JD 08.07.01</u>	Due Date : 7/14/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JD 08.07.01</u>	
Comment : Est Rev:A New Issue 06-06-19 JLM	
Est Rev:B Now water jet 06-07-14 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.4200 sf(s)/Unit Total: 2.5200 sf(s)
 UHMW 1" Black ~~18-8-19~~
 batch: 108645 ~~18-8-19~~

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2916 ~~18-8-19~~
 Dwg Rev: B ~~18-8-19~~
 Prog Rev: B

⑥

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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⑥ →

Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: 1086451- Mill as per Folio FA2916-5 Rev: A & Dwg D2916 Rev: B

2-Deburr per dwg D2916

J.L./08/08/20

W/O: 40154		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2916-S PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: 40154		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/15	4	- 1 part is scrapped. Program was Ran at 2 ϕ PAR run program at ϕ see Date EC no retract in 2 order main position	<i>[Signature]</i>	Scrap destroy and B# Replace Qty (4)	<i>[Signature]</i> 08/08/19 B# 8-8-19	<i>[Signature]</i> 06/08/22	<i>[Signature]</i>	<i>[Signature]</i> 06/08/19
8/8/19	# 4.0	5 parts scrap due to holes being off by 0.060" R.L. Tooling / base plate starting to wear out.	<i>[Signature]</i>	Scrap and destroy and replace B# 108645 Qty (5) Fix tooling	<i>[Signature]</i> 08/08/19 B# 8-8-19	<i>[Signature]</i> 06/08/22	<i>[Signature]</i>	<i>[Signature]</i> 06/08/19

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 10:46:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 40154

Part Number: D29165

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/08/20

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.S 08/08/20 (67)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1/1 08.08.20

7

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



MF 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40154
Description: Cable Guard		Part Number:	D2916-5
Inspection Dwg: D2916	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

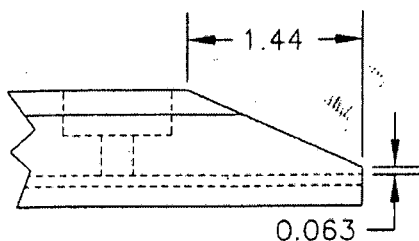
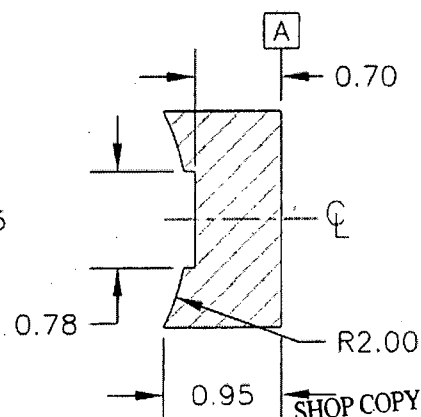
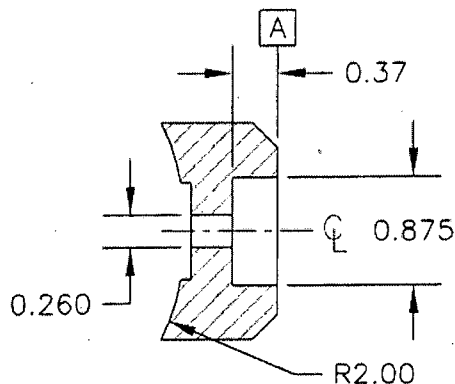
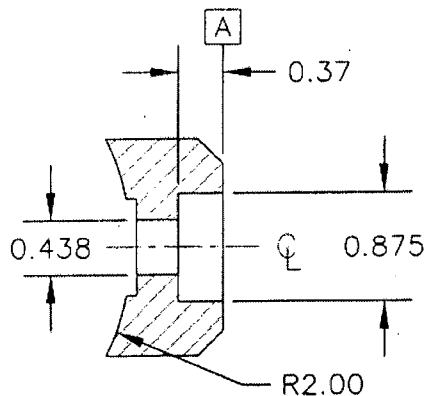
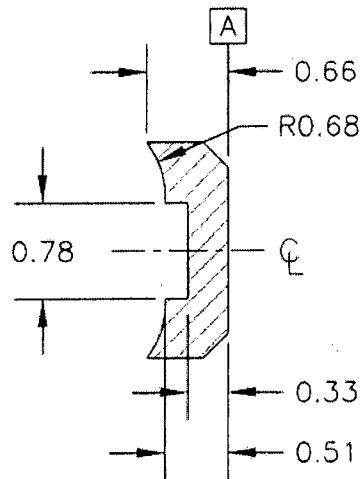
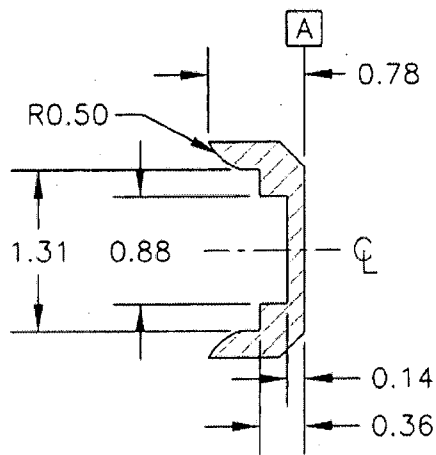
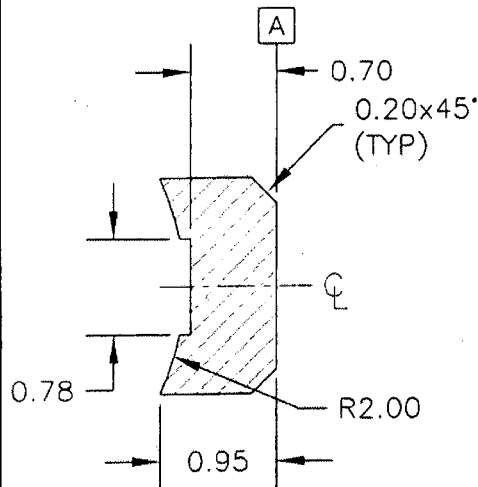
☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+/-0.030	1.753	✓			
32.13	+/-0.030	32.13	✓			
28.94	+/-0.030	28.94	✓		tape	
20.81	+/-0.030	20.81	✓		tape	
7.00	+/-0.030	6.970	✓			
5.000	+/-0.010	4.998	✓			
13.188	+/-0.010	13.188	✓			
30.125	+/-0.010	30.125	✓			
0.37	+/-0.030	.371	✓			
D-D Ø0.438	+0.005/-0.000	.438	✓			
0.875	+/-0.010	.871	✓			
0.37	+/-0.030	.371	✓			
E-E 0.875	+/-0.010	.868	✓			
Ø0.438	+0.005/-0.000	.438	✓			
1.44	+/-0.030	1.450	✓			
0.063	+/-0.010	.070	✓			

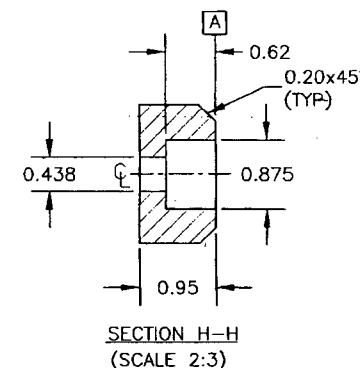
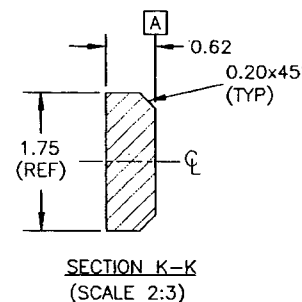
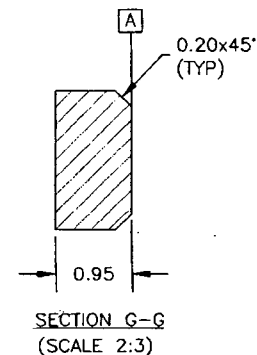
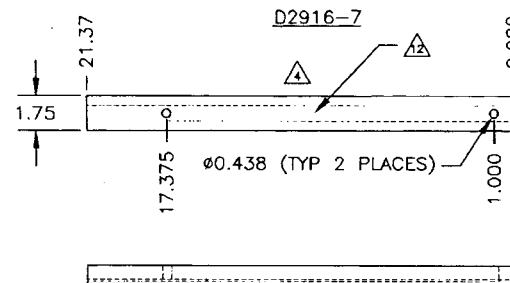
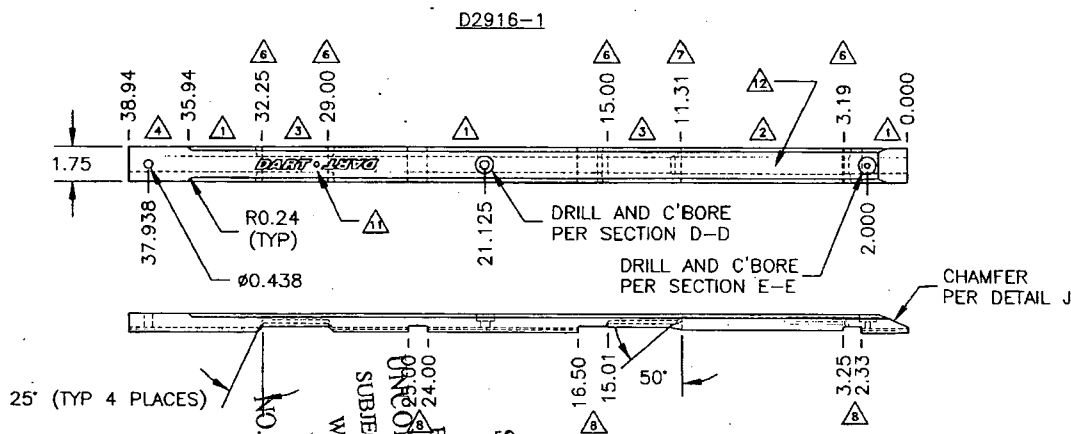
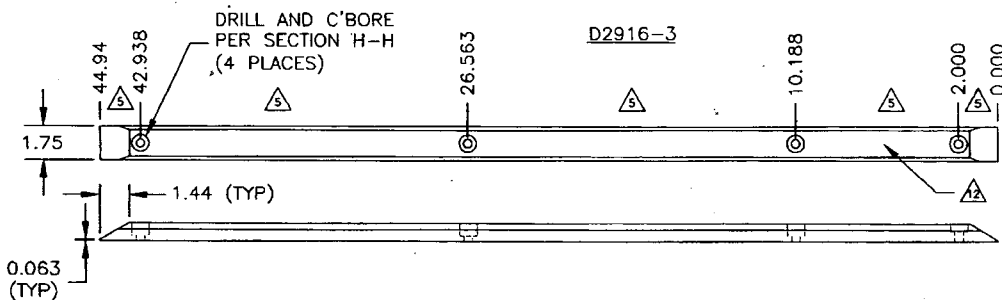
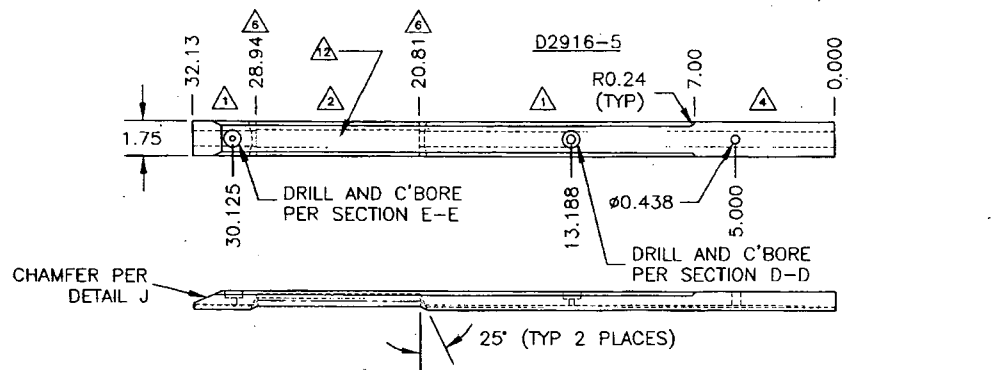
Measured by: <i>JB</i>	Audited by: <i>SP</i>	Prototype Approval:	N/A
Date: 8-7-23 / 08/08/17	Date: 08/08/20	Date:	N/A
Rev	Date	Change	Revised by
A	04.01.12	New Issue	KJ/RF
			Approved
			<i>[Signature]</i>



DESIGN #	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



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WITHOUT NOTICE
WORK ORDER
NO. 40154
RELEASED
00.02.25 DS



NOTES:

- 1) MACHINE CONSTANT SECTION A-A
- 2) MACHINE CONSTANT SECTION B-B
- 3) MACHINE CONSTANT SECTION C-C
- 4) MACHINE CONSTANT SECTION F-F
- 5) MACHINE CONSTANT SECTION G-G
- 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
- 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
- 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
- 13) ALL HOLES DRILLED ON CENTERLINES
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 15) ALL DIMENSIONS ARE IN INCHES

RELEASED

DESIGN	DRAWN BY	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. B
CHECKED	APPROVED	DRAWING NO. D2916	SHEET 2 OF 2
DATE		TITLE CABLE GUARD	SCALE 1:6
00.02.24			

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